

5/42

| | | | |
|--|--|---------------------|-----------|
| DART AEROSPACE LTD | | Work Order: | 24346 |
| Description: Cover Assembly, LH | | Part Number: | D3163-041 |
| Dwg: D3163 Rev. B | | Qty: | 3 |
| Page 1 of 1 | | | |


| Step | Location | Procedure | By | Date | Qty | | | | | | | | | | | | |
|------|--------------|--|-------------|-------------|-------------|-------|-----|--------------|------------------|---------|----|------------|-----------|---------|----|----------|---|
| 1 | DC | Issue Traveler | [Signature] | 05.10.25 | 3 | | | | | | | | | | | | |
| 2 | CA | Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3163-1</td><td>Plate</td><td>B 24613</td></tr><tr><td>1</td><td>D3163-3</td><td>Plate</td><td>B 24613</td></tr></table> | Qty | Part Number | Description | Batch | 1 | D3163-1 | Plate | B 24613 | 1 | D3163-3 | Plate | B 24613 | ml | 05/10/25 | 3 |
| Qty | Part Number | Description | Batch | | | | | | | | | | | | | | |
| 1 | D3163-1 | Plate | B 24613 | | | | | | | | | | | | | | |
| 1 | D3163-3 | Plate | B 24613 | | | | | | | | | | | | | | |
| 3 | CA | Bond D3163-3 to D3163-1 using Sikaflex. Ensure holes line up Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>A/R</td><td>N/A</td><td>Sikaflex 241/291</td><td>M18467</td></tr></table> Expiry Date: 12 Dec 2005 | Qty | Part Number | Description | Batch | A/R | N/A | Sikaflex 241/291 | M18467 | ml | 05/10/25 | 3 | | | | |
| Qty | Part Number | Description | Batch | | | | | | | | | | | | | | |
| A/R | N/A | Sikaflex 241/291 | M18467 | | | | | | | | | | | | | | |
| 4 | QC5 | Inspect bonding of D3163-1/-3 | [Signature] | 05.10.31 | 3 | | | | | | | | | | | | |
| 5 | FP | Powder Coat Grey Sandtex (Ref: 4.3.5.6) per QSI 005 4.3 | ml | 05.11.02 | 3 | | | | | | | | | | | | |
| 6 | QC3 | Inspect Powder Coat | ml | 05.11.02 | 3 | | | | | | | | | | | | |
| 7 | CA | C'sink D3163-3 as per Dwg D3163. Touch up c'sink holes with alodine. | ml | 05.11.02 | 3 | | | | | | | | | | | | |
| 8 | CA | Assemble nut plate as per Dwg D3163 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>4</td><td>MS20426AD3-4</td><td>Rivet</td><td>M13786</td></tr><tr><td>2</td><td>MS21059L08</td><td>Nut Plate</td><td>M10015</td></tr></table> Identify as D3163-041 | Qty | Part Number | Description | Batch | 4 | MS20426AD3-4 | Rivet | M13786 | 2 | MS21059L08 | Nut Plate | M10015 | ml | 05/11/02 | 3 |
| Qty | Part Number | Description | Batch | | | | | | | | | | | | | | |
| 4 | MS20426AD3-4 | Rivet | M13786 | | | | | | | | | | | | | | |
| 2 | MS21059L08 | Nut Plate | M10015 | | | | | | | | | | | | | | |
| 9 | QC5 | Inspect work to current Step | [Signature] | 05.11.03 | 3 | | | | | | | | | | | | |
| 10 | ST | Identify top assembly on the back side of assembly with Dart P/N and B/N using fine point permanent ink marker and Stock | ml | 05/11/03 | 3 | | | | | | | | | | | | |
| 11 | AC | Cost / part: 123.77 | SUC | 05.11.04 | 3 | | | | | | | | | | | | |
| 12 | DC | Close W/O 62.10 Inspect Level 21 | [Signature] | 05/11/04 | 3 | | | | | | | | | | | | |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|-------------|
| A | 05.10.25 | New issue | KJ/RF | [Signature] |

RELEASED
05.10.25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/11/09

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

QA COPY ISSUED

HAWKESBURY, ONTARIO, CANADA

REV. B

SHEET 1 OF 1

SCALE

04.10.06

PLATE

A

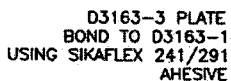
NEW ISSUE

2

HOLES

R0.125
(TYP)

RELEASE
04-11-23



D3163-041 PLATE SHOWN. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-19
(D3163-042 PLATE OPPOSITE. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-20)



GENERAL NOTES:

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 24346

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 26, 2005
10:48 am

Work Order No : 0024346
Project Name : D3163-041
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3163-041
Description : Cover Assembly
Manufactured : Yes
Amount Req'd :
Amount Done :
Start Date : 09-26-05
Est Finish Date : 10-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours : | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours : | 0.00 | 0.00 | 0.00 | | |
| Production Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours : | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours : | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours : | 0.00 | 0.00 | 0.00 | | |
| CNC : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours : | 0.00 | 0.00 | 0.00 | | |
| Misc. : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden : | 0.00 | 0.00 | 0.00 | | |
| Total Cost : | 0.00 | 0.00 | 0.00 | | |
| Mark up : | 0.000 | 0.000 | | | |
| Selling Cost : | 0.00 | 0.00 | | | |

| | | |
|--------------------------|-----------|--------|
| | Estimated | Actual |
| Labour Hrs/Amount Done : | 0.00 | 0.00 |
| Profits/(Loss) : | 0.00 | 0.00 |